

day, 25/03/2009 10:55:15 AM

on

## Process Sheet

CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD LH, EC 130 B4
45459	Part Number	: D130780041
13761	Drawing Number	: IIN-D130-780
Issue	Project Number	: N/A
25/03/2009 S.O. No. :	Drawing Revision	: A
NC	Material	:
03/02/2009 Type : PURCHASED PARTS	Due Date	: 01/03/2009 Qty: 1 Um: Each
45458		
Written By		
Checked & Approved By		
Comment	: Est Rev:A 09-02-03 new issue DD verified by:JLM	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels per PPP D130-780-041 CHG 001

2.0

D130780043

Spacepod Door Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Door Assembly, LH

batch: 345535

090504

3.0

D130780011

Door Hinge, Aft, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Hinge, Aft, LH

batch: 345530

090506

4.0

D130780013

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Relocation

batch: 345533

090505

5.0

D31881M

SPACEPOD BODY LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACEPOD BODY LH

batch: 345697

090504

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 25/03/2009 10:55:16 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45459

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AKS71032130

Insert



ALS4-1632-130



PTO

Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Insert

batch:

M110511

SS 09/04/28 (X)

7.0

D38373

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch:

B46232

SS 09/04/28 (X)

8.0

D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Striker Plate

batch:

43938

SS 09/04/28 (X)

9.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

batch:

41067

SS 09/04/28 (X)

10.0

D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Hinge Bracket

batch:

35454

SS 09/04/28 (X)

11.0

D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Doubler

batch:

36630

SS 09/04/28 (X)

12.0

AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

screw

batch:

M104603

SS 09/04/28 (X)

Dart Aerospace Ltd

W/O: 45459		ESTIMATE: 13761		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090504	6.0	AKS71032 130 <del>should</del> be changed To ALS41032 130 <i>Permanent Change</i>	<i>[Signature]</i>	09.04.28		<i>[Signature]</i> Q9122	<i>[Signature]</i> 09.05.04	

Part No: D130-780-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45459

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch:

M110844

SS 09/04/28 (X)

14.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch:

M110002

SS 09/04/28 (X)

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

-Assemble as per dwg D3188,

-use door to transfer drill hole location.

-Install inserts

SS 090429

(P10)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 09-05-06

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch:

M111013

SS 09-05-06 D.

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SS 09/05/06 (X)

LA

19.0




PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

pick kit:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
090428	15.0	Modify BOTTOM outside edge 2.00 in x .60 in, remove, INSTALL 9 oz. Satin w/ 9330 Hysol AB as req'd.  	#	090429		 09.04.28	 09.05.04	
		9oz Satin <sup>K2.0 in</sup> F4 7781050SS0 M111166 9330 milled fibre <u>M110416</u> <u>M100859</u>						

Also  
see next  
page

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45459

Part Number: D130780041

Job Number:



(P10)

Seq. #:

Machine Or Operation:

Description :

20.0

D3815041

Web Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Web Assembly

batch: 45729

SS 09/05/06 (X)

21.0

D38371

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

46231

SS 09/05/06 (X)

22.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Locknut

batch: 45394

SS 09/05/06 (X)

23.0

D3798041

Spacepod Floor, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Spacepod Floor, LH

batch: 45578

SS 09/05/06 (X)

24.0

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

batch: 35445

SS 09/05/06 (X)

25.0

D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

batch: B45570

SS 09/05/06 (X)

26.0

D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ball Stud

batch: B37674

SS 09/05/06 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-04-30	15.1	Prime grey 2k primer as per Q31005 <u>MA 110582</u>	<i>mm</i>	09-04-30	1	<i>Q31042</i>	<i>09-04-30</i>

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45459

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN33A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:

M111193

SS 09/05/06 (X)

28.0

AN36A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:

M109752

SS 09/05/06 (X)

29.0

AN310A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch:

M17560

SS 09/05/06 (X)

30.0

AN55A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

batch:

M110363

SS 09/05/06 (X)

31.0

AN52510R7

Screw



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Screw

batch:

M110914

SS 09/05/06 (X)

32.0

AN526C832R14

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch:

M104916

SS 09/05/06 (X)

33.0

MS24694S67

Screw



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Screw

batch:

M106106

SS 09/05/06 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45459

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

MS24694S69

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

batch:

M103574

SS 09/05/06 (X)

35.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer - Countersunk

batch:

M106150

090504

1

36.0

NAS1149D0363J

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch:

M110985

SS 09/05/06 (X)

37.0

NAS1149D0332J

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

batch:

M110625

SS 09/05/06 (X)

38.0

NAS1149D0563J

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

batch:

M110523

SS 09/05/06 (X)

39.0

MS21042L3

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

batch:

M110844

SS 09/05/06 (X)

40.0

MS21042L5

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Nut

batch:

M109840

SS 09/05/06 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD LH, EC 130 B4

Job Number: 45459

Part Number: D130780041

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

ALS71032130

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

ALS7-1032-130

batch:

111529

(AKS7-1032-130)

8809105/06 (X1)

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8809105/06 (X1 LH)

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D130-780-041

Location:

PPP Rev:

DRPFT

PC 9/5/6 C

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09105/07 J

Job Completion



MF  
09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	Part Number	Description
X						D130-780-041	SPACEPOD™ LH, EC 130 B4
	X					D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X				D130-780-043	DOOR ASSEMBLY, LH
	1		X			D130-780-044	DOOR ASSEMBLY, RH
1				X		D130-780-011	AFT LH DOOR HINGE KIT
1	1				X	D130-780-013	SWITCH RELOCATION KIT
2	2					D3815-041	WEB ASSEMBLY
						D2464-0360	NEOPRENE SEAL
		1	1			D2589	KEYS, KEY CHAIN
1	1					D3837-1	DECAL
1	1					D3015-3	LOCK NUT
		1				D3186-3	SPACEPOD™ DOOR, LH
			1			D3186-4	SPACEPOD™ DOOR, RH
1						D3798-041	FLOOR
	1					D3798-042	FLOOR
1						D3188-5	SPACEPOD™ BODY
	1					D3188-6	SPACEPOD™ BODY
1	1					D3547-1	BRACKET
1	1					D3550-1	STRUT
		1	1			D3552-7	GAS SPRING
1	1					D3554-7	BALL STUD
4	4					AN3-3A	BOLT
4	4					AN3-6A	BOLT
2	2					AN3-10A	BOLT
1	1					AN5-5A	BOLT
38	38					AN525-10R7	SCREW
8	8					AN526C832R14	SCREW
7	7					MS24694S67	SCREW
1	1					MS24694S69	SCREW
		2	2			MS27039-0811	SCREW
8	8					A3235-020-935	WASHER
8	8					NAS1149D0363J	WASHER
16	16					NAS1149D0332J	WASHER
		4	4			NAS1149DN832J	WASHER
3	3					NAS1149D0563J	WASHER
		2	2			NAS1515H3	NYLON WASHER
		2	2			MS21042L08	NUT
16	16					MS21042L3	NUT (or MS21042-3)
1	1					MS21042L5	NUT
10	10					AKS7-1032-130	INSERT
28**	28**					AKS7-1032-130	INSERT
					2	D3819-1	MALE SPADE CONNECTOR
					2	D3597-1	FEMALE SPADE CONNECTOR

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UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 Revision: A  
 Date: 08/10/2009  
 NO. 43439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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-041	-042	-043	-044	-011	-013	Part Number	Description
					1	D3598-2-096	EXPANDABLE SLEEVE
					24	D3599-1	TIE-WRAP
					24	D3600-1	TIE-WRAP MOUNT
					24 FT	M22759/41-22-9	WIRE
		1*	1*			D2464-1250	NEOPRENE SEAL
1**		1*				D3837-3	DECAL
	1**		1*			D3837-4	DECAL
		2*	2*			D2586	LATCH
		2*	2*			D2585	MOUNTING CHANNEL
		2*	2*			D2621	LATCH PLATE
		2*	2*			MS27039-1-15	SCREW
		2*	2*			NAS1149D0363J	WASHER
		2*	2*			MS21042L3	NUT (or MS21042-3)
		1*	1*			D2857-1	HINGE BRACKET
		1*	1*			D2857-2	HINGE BRACKET
		2*	2*			D2228	BACKING PLATE
		8*	8*			AN526C832R10	SCREW
		8*	8*			NAS1149DN832J	WASHER
		8*	8*			MS21042L08	NUT
		1*	1*			D3557-1	BRACKET
		2*	2*			D2228	BACKING PLATE
		1*	1*			D3554-7	BALL STUD
		1*	1*			NAS1149D0563J	WASHER
		1*	1*			D3015-3	LOCK NUT
		2*	2*			AN526C832R14	SCREW
		2*	2*			AN526C832R10	SCREW
		4*	4*			NAS1149DN832J	WASHER
		4*	4*			MS21042L08	NUT
2**	2**					D2237	STRIKER PLATE
4**	4**					MS20426AD4-5	RIVET
2**	2**					D3538-1	HINGE BRACKET
2**	2**					D2179	HINGE BRACKET PLATE
4**	4**					AN526C832R24	SCREW
4**	4**					NAS1149DN832J	WASHER
4**	4**					MS21042L08	NUT
				1		D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1		D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***		D3518-3	ROD END
				2***		NAS509-6	NUT
				1		D3814-1	HINGE, UPPER AIRFRAME
				1		D3814-3	HINGE, LOWER AIRFRAME

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

Revision: A WITHOUT NOTICE

Date: 08.10.07

NO. 45459

SHOP COPY  
RETURN TO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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-041	-042	-043	-044	-011	-013	Part Number	Description
				2		D3816-1	SPACER
				4		D3816-3	SPACER
				1		D3817-041	ANCHOR PLATE
				2		AN3-5A	BOLT
				3		AN3-7A	BOLT
				2		AN310-4	CASTLE NUT
				2		AN4-17	BOLT
				2		AN970-4	WASHER
				5		MS21042L3	NUT
				2		MS24665-212	COTTER PIN
				3		MS24694S46	SCREW
				8		NAS1149D0363J	WASHER
				2		NAS1149D0463J	WASHER
				1		D3552-7	GAS SPRING
				2		D3622-1	BALL STUD
				1		D3820-1	DOOR SUPPORT
				2		MS21042L5	NUT
				2		NAS1149D0563J	WASHER

\* Pre-installed on D3186-3/-4 Spacepod™ Door

\*\* Pre-installed on D3188-5/-6 Spacepod™

\*\*\* Pre-installed on D3813-041/-043 Hinge Assemblies

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WITHOUT NOTICE  
WORK ORDER  
Revision: A. 45459  
Date: 08.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED

07.04.09

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
JB	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 11
CE	[Signature]	D3188	
DATE	TITLE	SPACEPOD BODY	SCALE
07.04.02			NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	
E	07.04.02	ADD. HYSOL/FIBER OPTION ON SHEET 11	

#### GENERAL NOTES:

- 1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

- 4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

- 7) ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

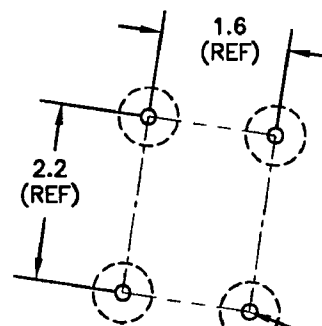
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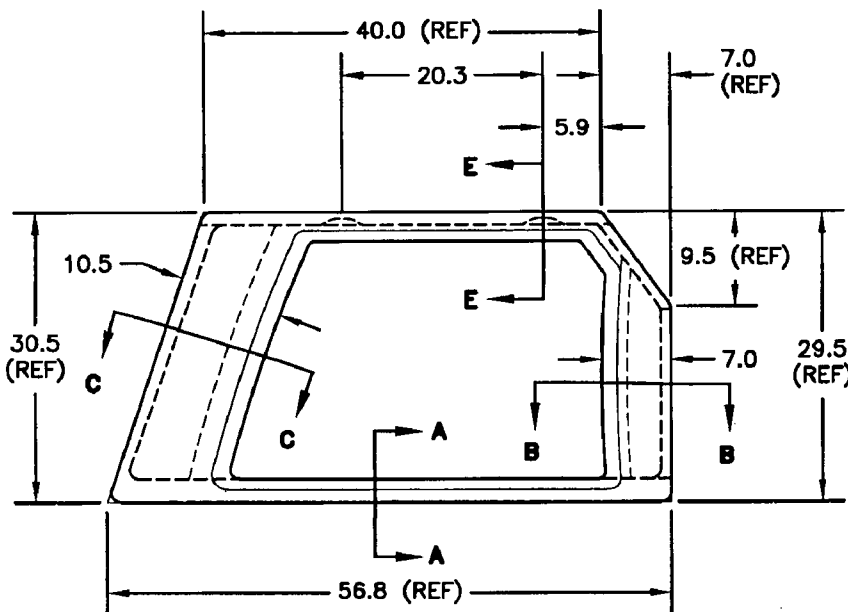
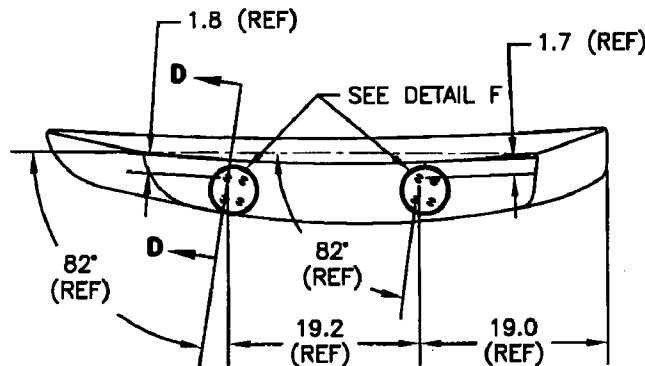
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07-04-02

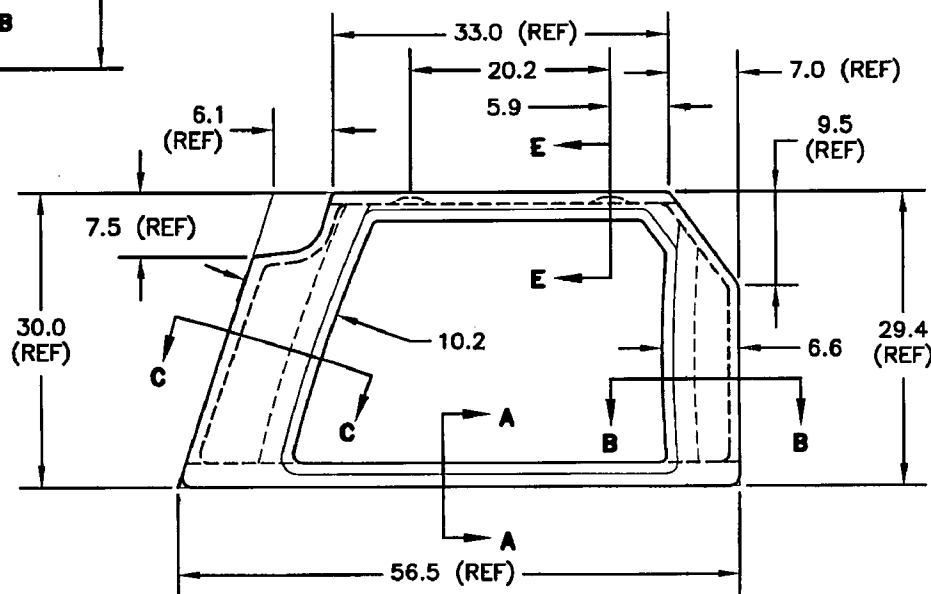
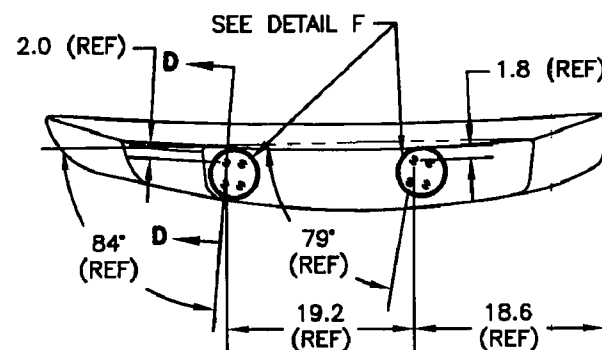
INSTALL  
D2213 SPACER  
(8 PLACES)  
(SEE SECTION D-D)



**DETAIL F**



**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**

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CHECKED	CE	APPROVED	CB	DRAWING NO. D3188
DATE	07.04.02	TITLE	SPACEPOD BODY	REV. E
				SHEET 2 OF 11
				SCALE
				NTS

**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #4 FOR SECTION VIEWS.

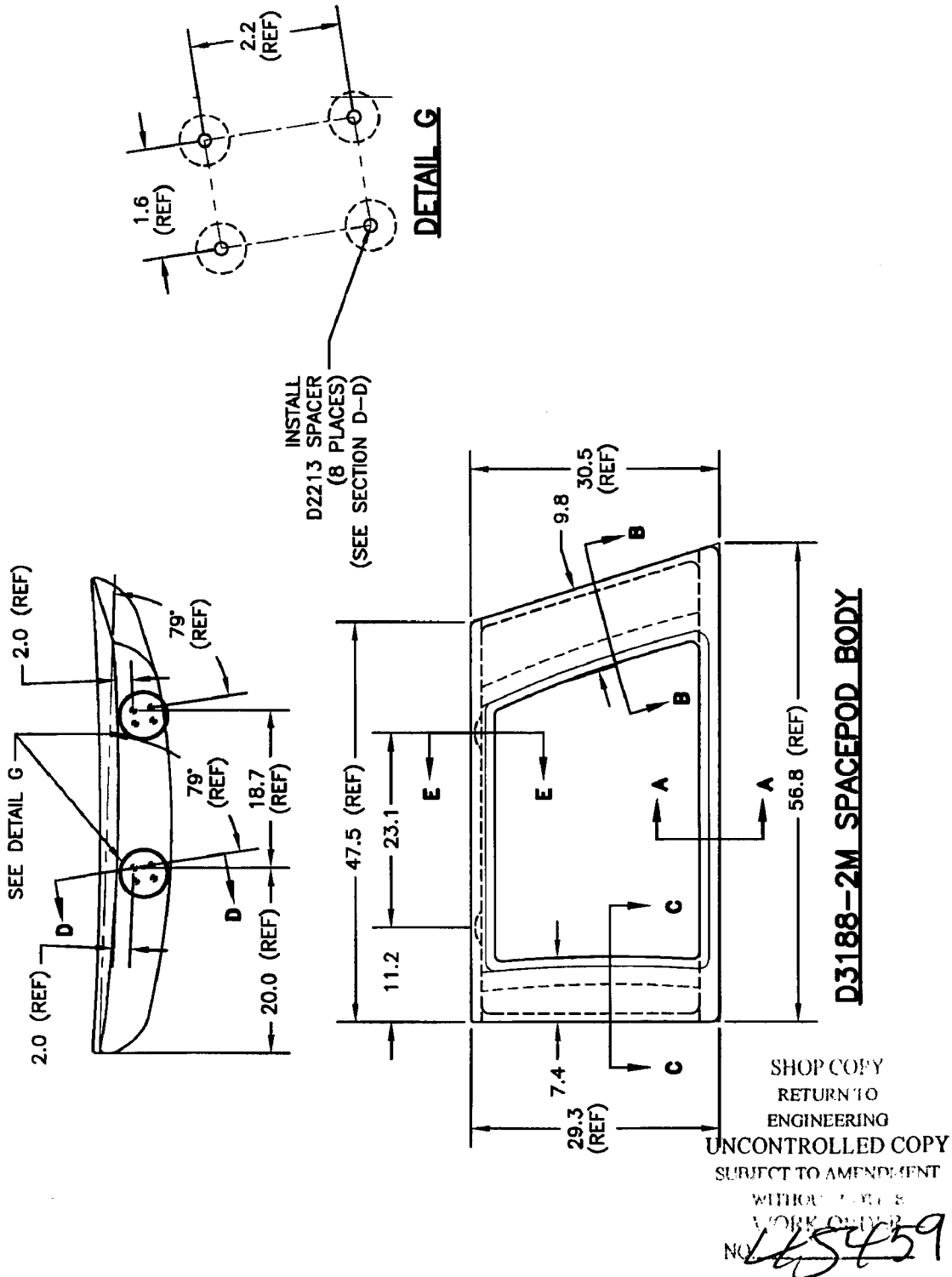
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

**RELEASED**07.04.02 **[Signature]**

D3186-2M NOTES:  
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.  
2) SEE SHEET #4 FOR SECTION VIEWS.

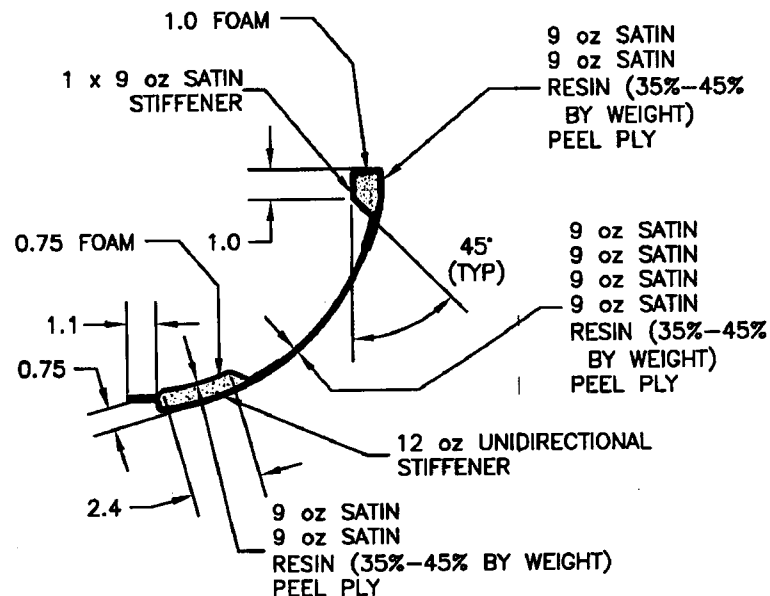
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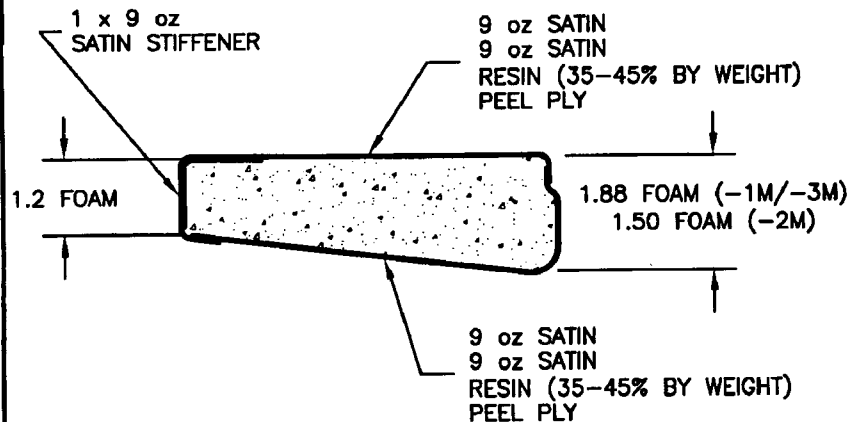
# DART

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DATE	07.04.02	TITLE	SPACEPOD BODY	SHEET	4 OF 11
		SCALE	NTS	REV. E	

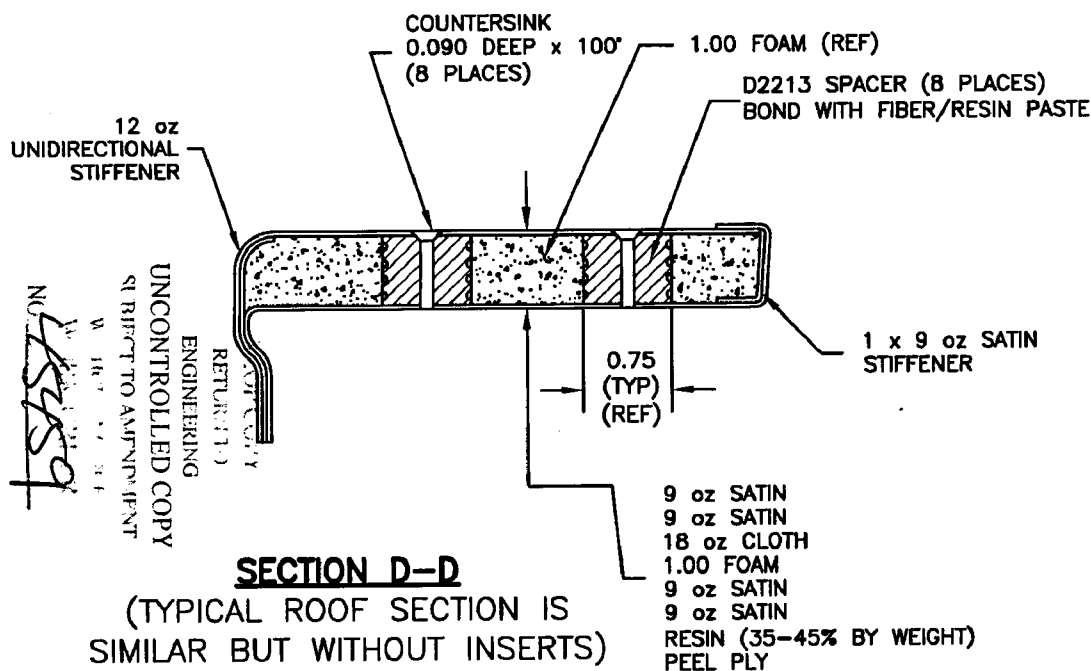
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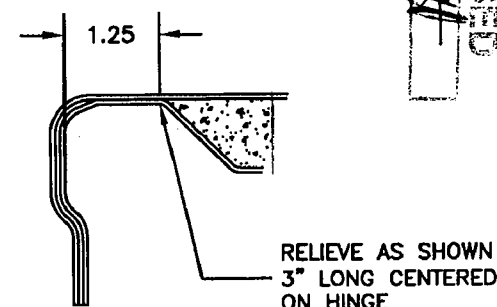
**SECTION B-B**  
(SECTION C-C OPPOSITE)



**SECTION A-A**  
(TYPICAL FLOOR SECTION)



**SECTION D-D**  
(TYPICAL ROOF SECTION IS  
SIMILAR BUT WITHOUT INSERTS)



**SECTION E-E**  
(2 PLACES PER POD)

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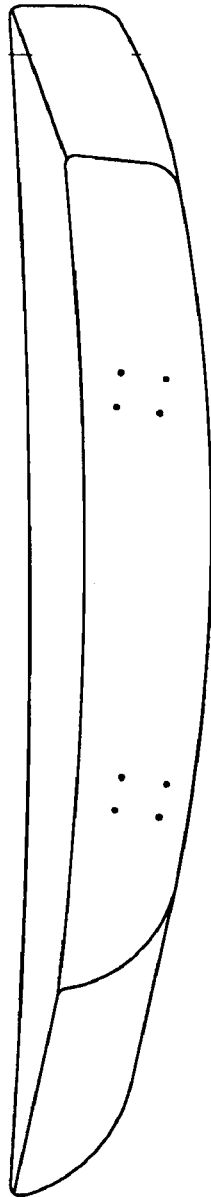


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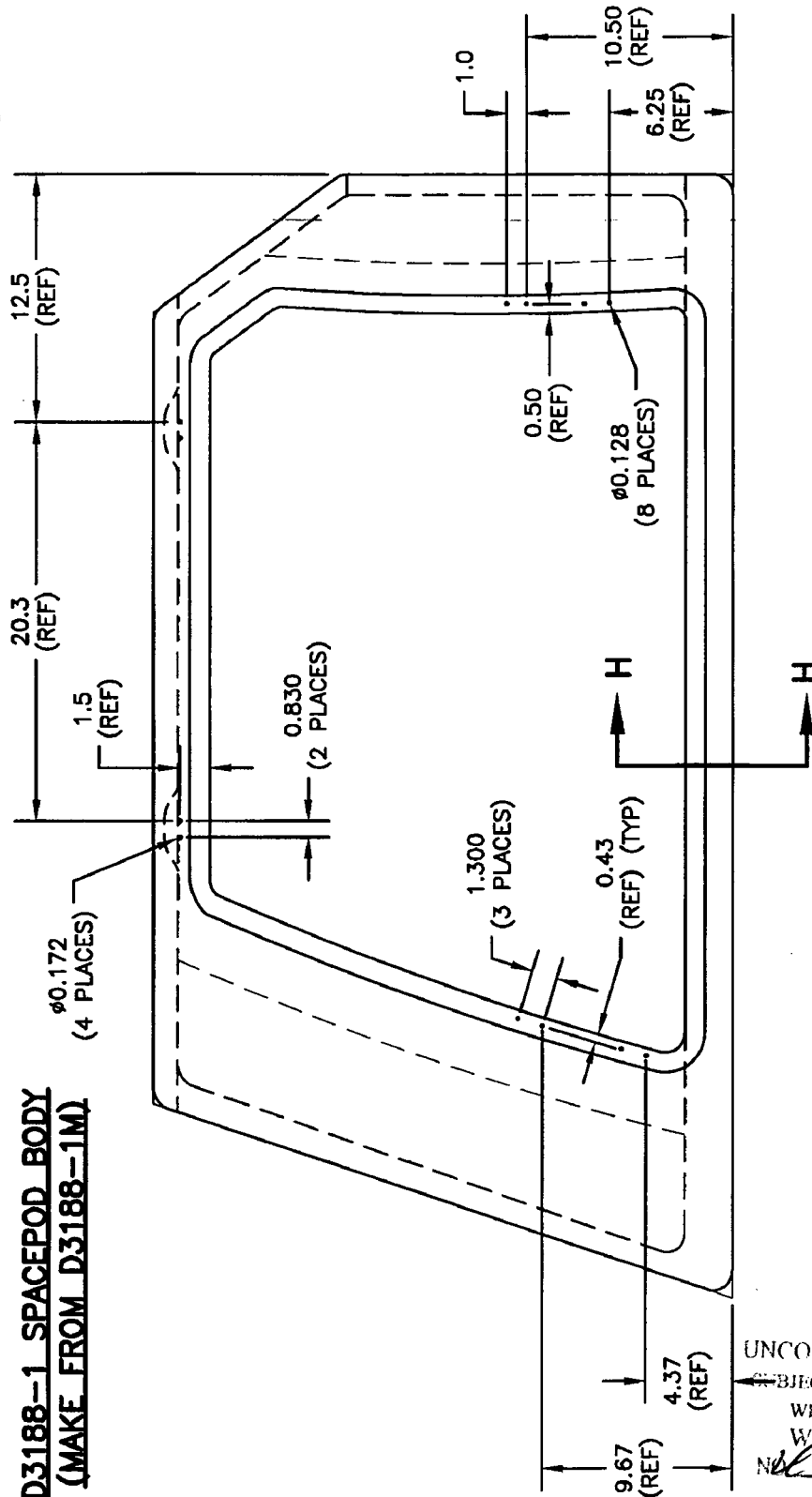
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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

RELEASED

07.04.02



**D3188-1 SPACEPOD BODY**  
**(MAKE FROM D3188-1M)**



**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

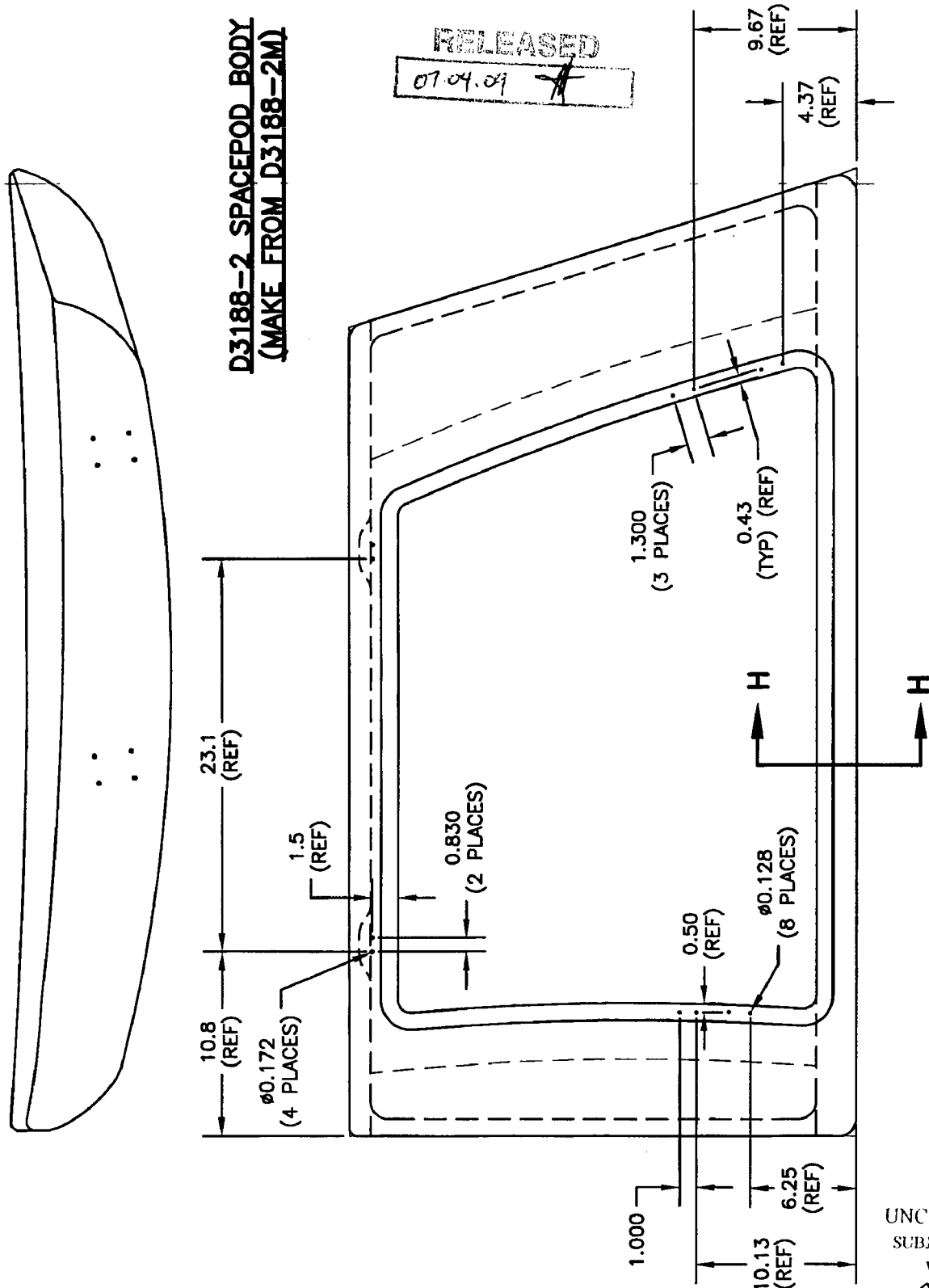
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
  - 2) SEE SHEET #11 FOR SECTION VIEW

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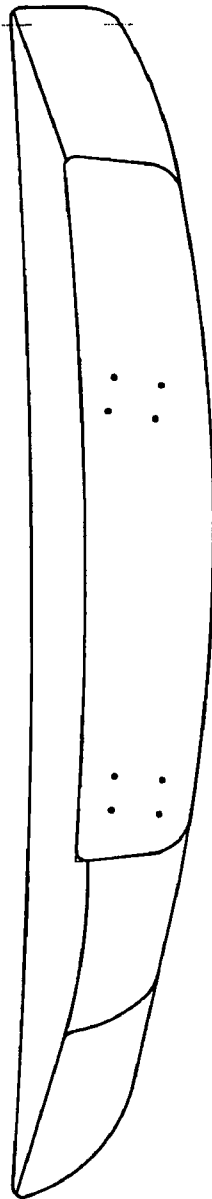
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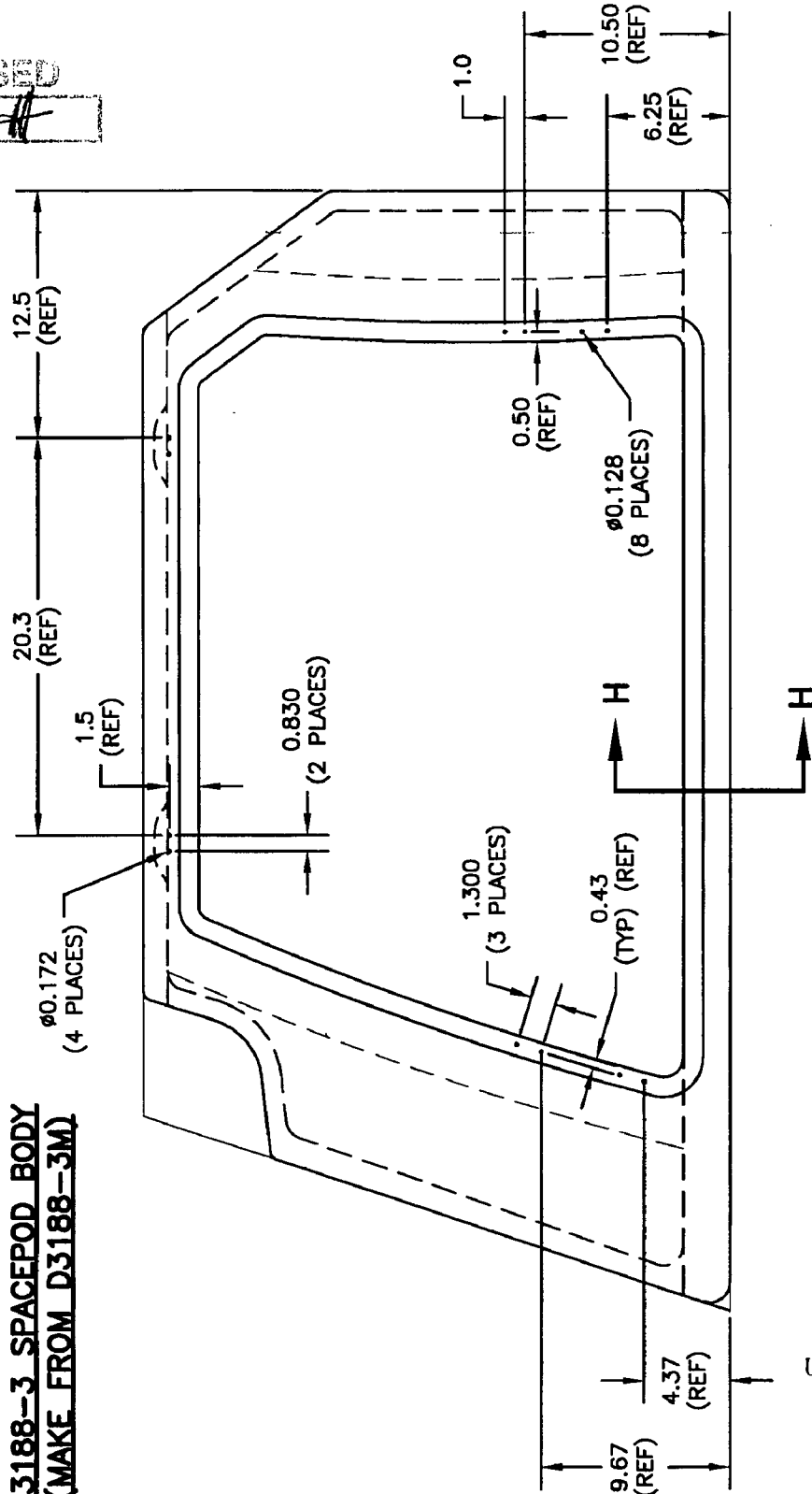
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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**D3188-3 SPACEPOD BODY**  
**(MAKE FROM D3188-3M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #111 FOR SECTION VIEW

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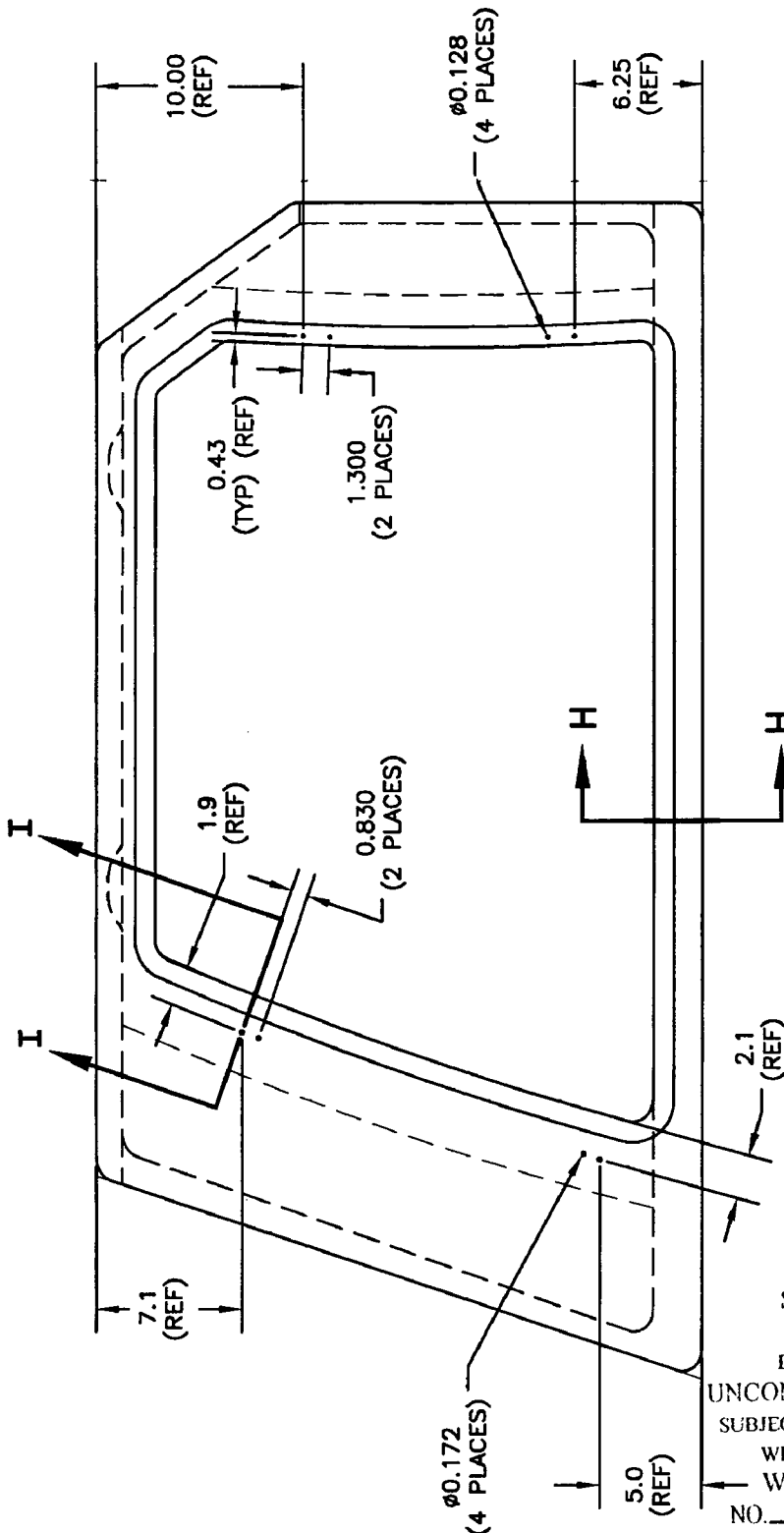
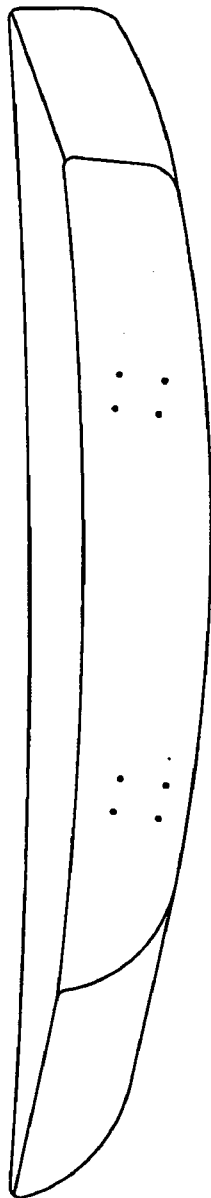


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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

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07.04.02

D3188-5 SPACEPOD BODY  
(MAKE FROM D3188-1M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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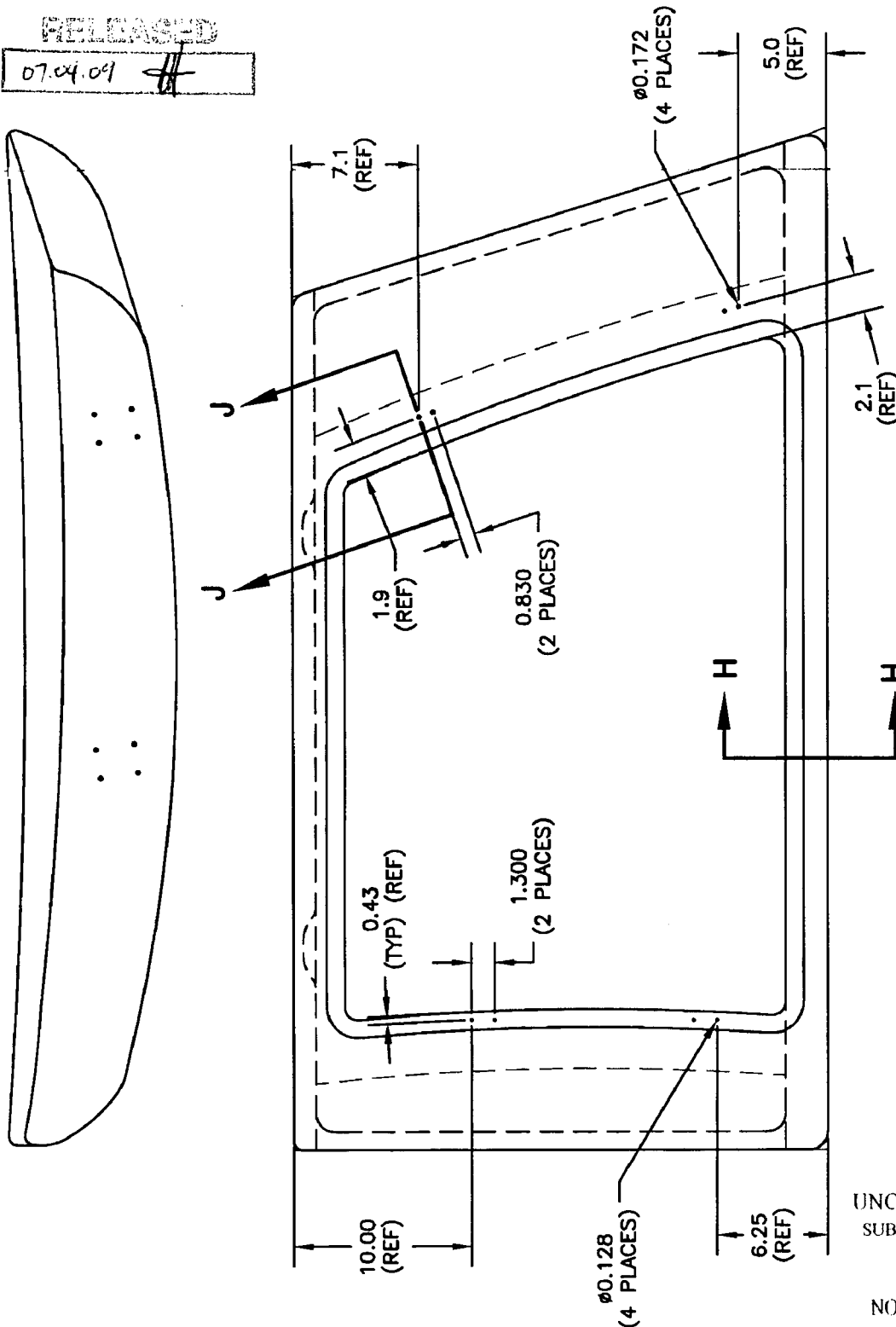
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**DART**

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DATE <b>07.04.02</b>		TITLE <b>SPACEPOD BODY</b>	SCALE NTS

**D3188-6 SPACEPOD BODY**  
**(MAKE FROM D3188-2M)**



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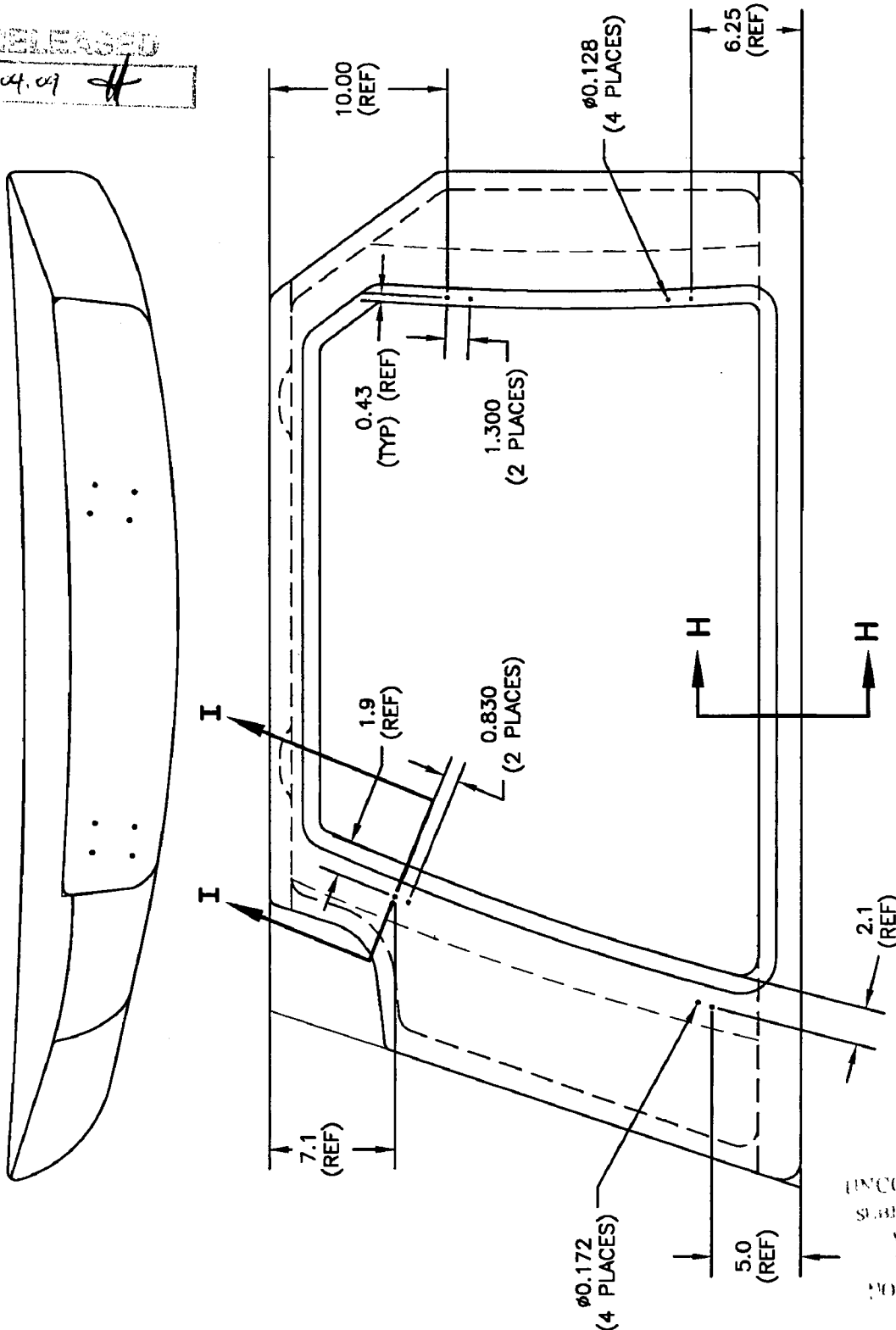
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DATE 07.04.02	TITLE SPACEPOD BODY		SCALE NTS

RELEASED

07.04.02

**D3188-7 SPACEPOD BODY  
(MAKE FROM D3188-3M)**



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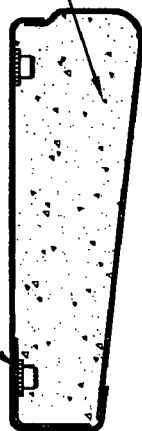
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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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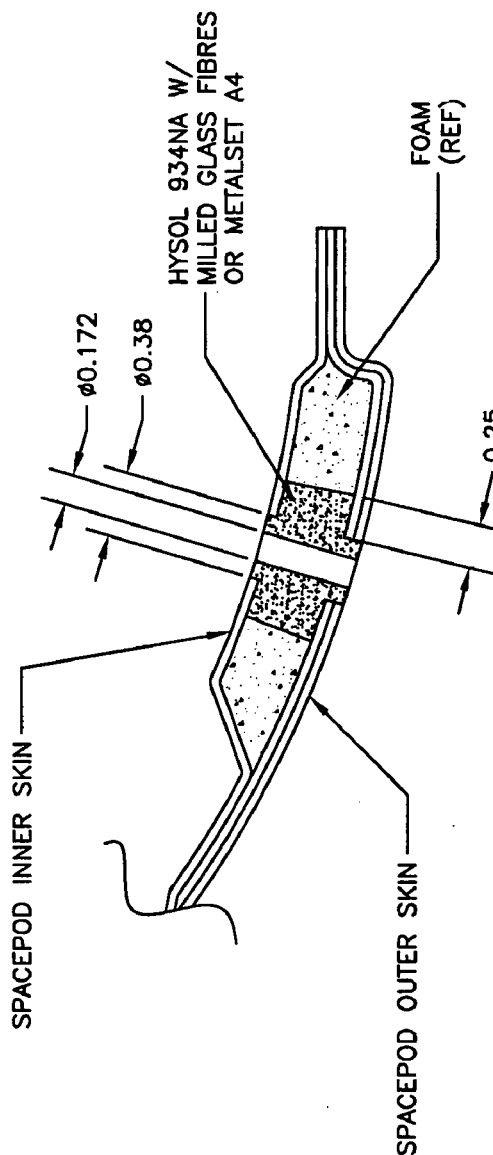
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INSTALL AKS7-1032-130  
INSERTS (29 PLACES)  
PER D3188-1T1 (D3188-1/-3/-5/-7)  
OR D3188-2T1 (D3188-2/-6)

FOAM  
(REF)



**SECTION H-H**  
(TYPICAL FLOOR SECTION)



**SECTION I-I**  
(SECTION J-J OPPOSITE)  
(4 PLACES PER POD)

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